



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D2661-1
Job Sheet 204815



Part No: D2661-1

Job Qty: 4 pcs

Part Name: Saddle, LH, Fwd, Aft, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/20/19

Job Tracking No:

Due Date: 2/10/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV E IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP REV:D REDESIGN
PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	4 pcs	2/10/20		1.00	4.49	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	Conventional Mill - 1 - B4B	4 pcs	2/10/20		0.00	2.56	Conventional Mill - 1 - B4B		
							Conventional Mill - 2 - B4B		
120	QC 2	4 pcs	2/10/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



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Container No: S274135



Part: D2661-1

Job No: 204815

Serial No/Batch: S274135

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/28/20

Plex 12/20/19 9:57 AM Dart.Renwick.Jennifer

				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130	QC 8	4	2/10/20	0.00 0.00	
	pcs				
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140	Handfinish - 1-1 Chemical-B4B	4	2/10/20	0.00 0.11	
	pcs				
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	

JSP 20-04-29

JH 20/4/29

JEB 20-04-30

1254469.				Handfinish - 1 - 22 - B4B		
150	Powdercoat - 1 White GI(A)- B4B	4 pcs	2/10/20	0.00 0.16	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160	QC 3	4 pcs	2/10/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
170	Packaging 3-1 - Stock - B4B	4 pcs	2/10/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 37 - B4B	
180	QC 21 - SA	4 pcs	2/10/20	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	
Part Op 100 - (HAAS CNC Vertical Machine) Descriptions: 110 - (Manufacture as per dwg) 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Chemical Conversion Coat per QSI005 4.1 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 160 - QC3- Inspect Part Finish 170 - Identify as per dwg & Stock Location: 180 - QC21- Final Inspection - Work Order Release						

34
9-89DAS
59
9-89DAS
28
9-89DAS
21
9-89

MAY 04 2020

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	4 pcs (1 ea)	100-HAAS 4 Axis	S272967
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-003	4	48	0
Part Specifications				
Specifications could not be found.				

Plex 12/20/19 9:57 AM Dart.Renwick.Jennifer

DART AEROSPACE LTD				Work Order:	
Description: 206 Saddle, Outboard, Left side				Part Number: D2661-1	
Inspection Dwg: D2661 Rev: E DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	
B	0.256	0.263		0.258	0.258	0.258	0.258	
C	0.315	0.322		0.316	0.316	0.316	0.316	
D	2.495	2.505		2.500	2.500	2.500	2.500	
E	1.674	1.684		1.679	1.679	1.679	1.679	
F	1.357	1.367		1.362	1.362	1.362	1.362	
G	0.100	0.140		0.125	0.125	0.125	0.125	
H	0.210	0.230		0.227	0.227	0.227	0.228	
I	0.615	0.685		0.685	0.685	0.685	0.685	
J	2.470	2.510		2.494	2.494	2.494	2.494	
K	1.313	1.343		1.325	1.325	1.325	1.325	
L	0.178	0.198		0.188	0.188	0.188	0.188	
M	0.470	0.530		0.500	0.500	0.500	0.500	
N	1.125	1.145		1.135	1.135	1.135	1.135	
O	0.100	0.180		0.135	0.135	0.135	0.135	
P	0.100	0.140		0.132	0.131	0.132	0.132	
Q	0.240	0.260		0.252	0.251	0.252	0.252	
R	0.677	0.697		0.687	0.689	0.688	0.688	
S	0.100	0.140		0.122	0.124	0.123	0.123	
T	1.565	1.585		1.575	1.575	1.575	1.575	
U	0.540	0.560		0.550	0.549	0.550	0.550	
V	0.912	0.932		0.923	0.923	0.923	0.922	
W	0.787	0.807		0.796	0.797	0.797	0.797	
X	5.990	6.010		6.002	6.001	6.001	6.001	
Y	4.995	5.005		5.000	5.000	5.000	5.000	
Z	0.490	0.510		0.499	0.500	0.500	0.500	
AA	0.312	0.319		0.313	0.313	0.313	0.313	
AB	0.990	1.010		1.004	1.004	1.004	1.004	
AC	1.245	1.255		1.250	1.250	1.250	1.250	
AD	0.490	0.510		0.500	0.500	0.500	0.500	
AE	3.745	3.755		3.750	3.750	3.750	3.750	
AF	0.235	0.240		0.239	0.239	0.239	0.239	
AG	0.510	0.515		0.511	0.511	0.511	0.511	
AH	0.100	0.120		0.110	0.110	0.110	0.110	
Accept/Reject								

Measured by: <i>[Signature]</i>	Date: 20-04-28
Audited by: <i>[Signature]</i>	Date: 20/4/29
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	<i>[Signature]</i>

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date : _____	Sequence #: _____		QTY Affected : _____		MRB (QSI042)
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			